

Date: Wednesday, 12/14/2005 4:03:14 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAR
Job Number	: 25242		
Estimate Number	: 10386		
P.O. Number	: N/A	Part Number	: D31961
This Issue	: 12/14/2005 S.O. No. : N/A	Drawing Number	: D3196 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25100	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 1/10/2006
Checked & Approved By	: <u>See comment below</u>	Qty:	10 Um: Each
Comment	: Est Rev: A New Issue 05-11-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
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Comment: Qty.: 2.2922 f(s)/Unit Total: 22.9215 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)

(M6061T6B0.750x01.500)

Identify for D3196-1

Batch: M18601 = 20'feet

M18571 = 26.200" inch

ml 05/12/16 10

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank: (0.75" x 1.50") x 26.200" long Bar

SD / ml 05/12/16 10 + 1

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3196-1 as per Folio FA339 and Dwg D3196 Identify as D3196-1

2-Deburr

SD 05.12.17 (11)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 05.12.17 (11)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

BG 05.12.18 10 + 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/14/2005 4:03:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25242

Part Number: D31961

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 05/12/201 11

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 06/01/12 11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

U 06/01/13 11 C2.

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 92

U 06/01/123 11

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUT 06/01/16 11 LSP 06/01/16 11

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25242
Description: Bar		Part Number:	D3196-1
Inspection Dwg: D3196 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.094	+/-0.010	26.100	/		Tape	
4.083	+/-0.010	4.082	/			
17.928	+/-0.005	17.930	/		Tape	
0.750	+/-0.005	.751	/			
1.500	+/-0.010	1.503	/			M.L. Width
Ø0.344	+0.005/-0.000	Ø.345	/			
Ø0.660 x 100°	+/-0.005	Ø.657 x 100°	/			
0.060 x 45°	+/-0.010	.065 x 45°	/			
0.750	+/-0.010	.751	/			M.L. Thickness
0.250	+/-0.010	.251	/			
3.583	+/-0.010	3.580	/			
9.000	+/-0.010	9.000	/		Tape	
16.844	+/-0.010	16.850	/		Tape	
21.511	+/-0.010	21.510	/		Tape	
R0.125	+/-0.010	R.125	/			
1.000	+/-0.010	1.000	/			
R0.125	+/-0.010	/	/	/	/	/

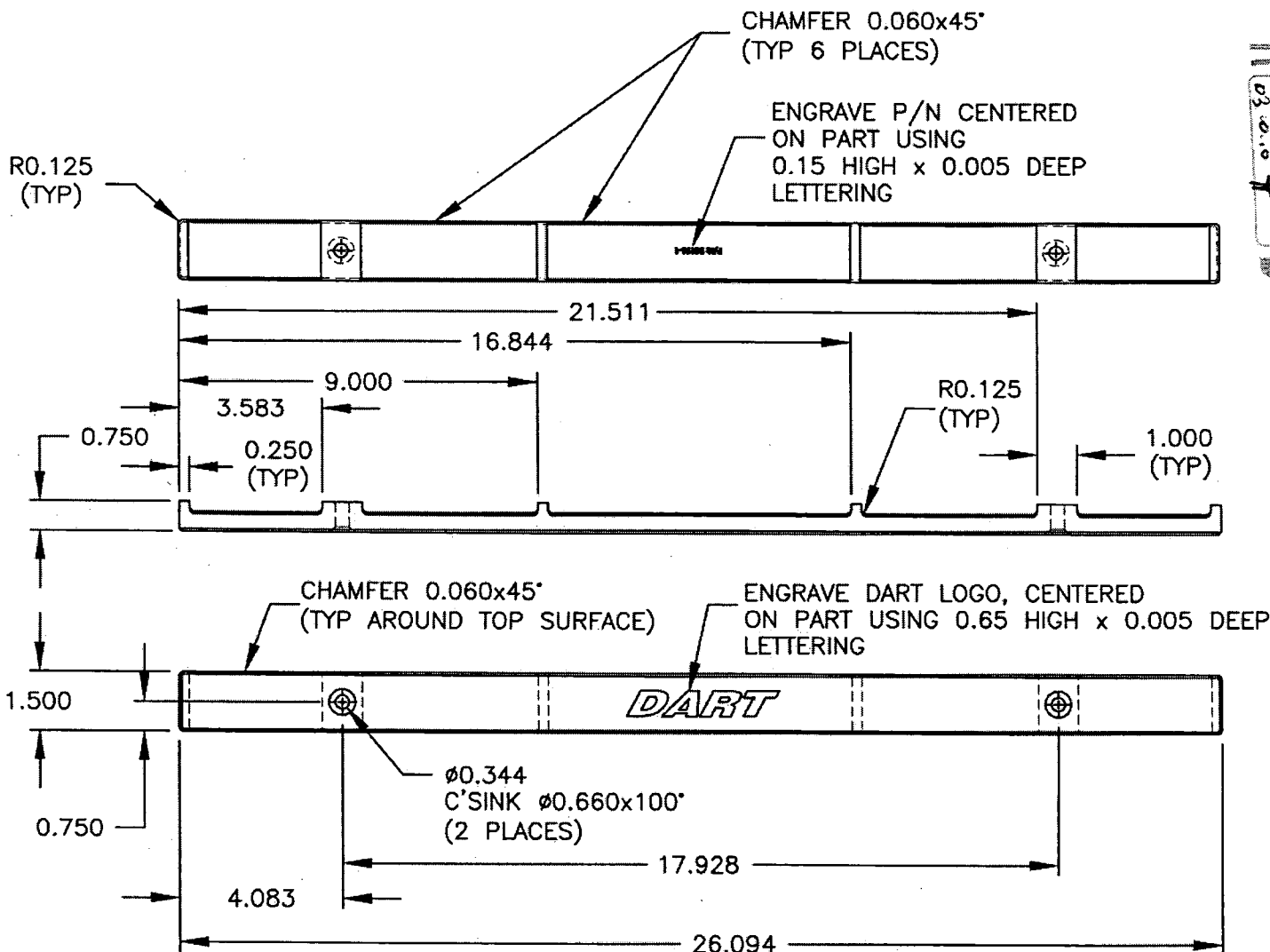
Measured by:	SD	Audited by:	B6 05.12.17	Prototype Approval:	N/A
Date:	05.12.17	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-01/-013)	KJ/RF	

QA COPY ISSUED

03-0-0

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. A
CHECKED	APPROVED		DRAWING NO.
DATE		TITLE	SHEET 1 OF 3
03.06.25		BAR	SCALE 1:4
A	03.06.25	NEW ISSUE	



D3196-1 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

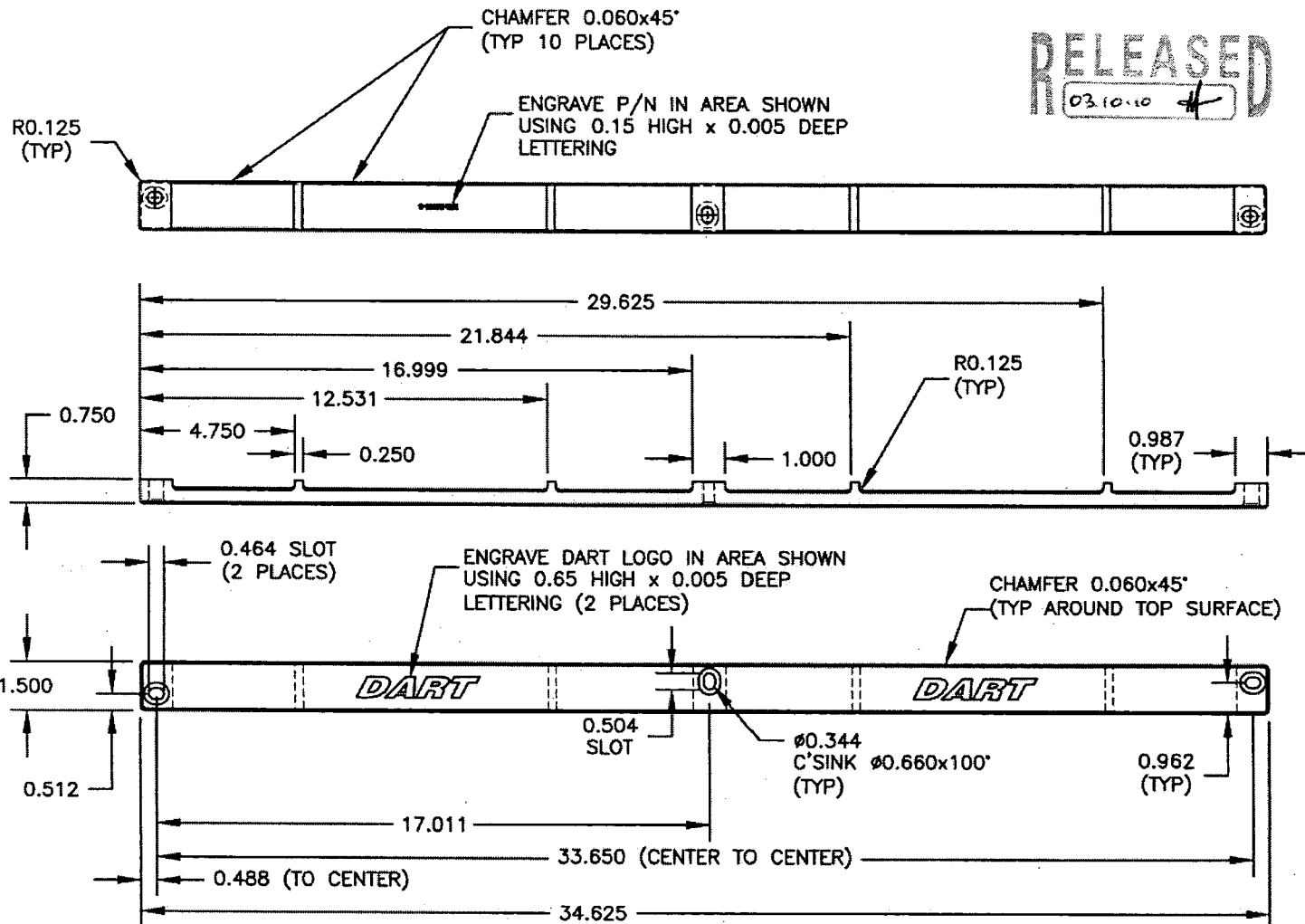
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25242



RELEASED
03.10.10

DART



DESIGN	APPROVED	DRAWING NO.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	D3196	REV. A
DATE	TITLE	BAR	SHEET 2 OF 3
03.06.25			SCALE 1:5

D3196-3 BAR

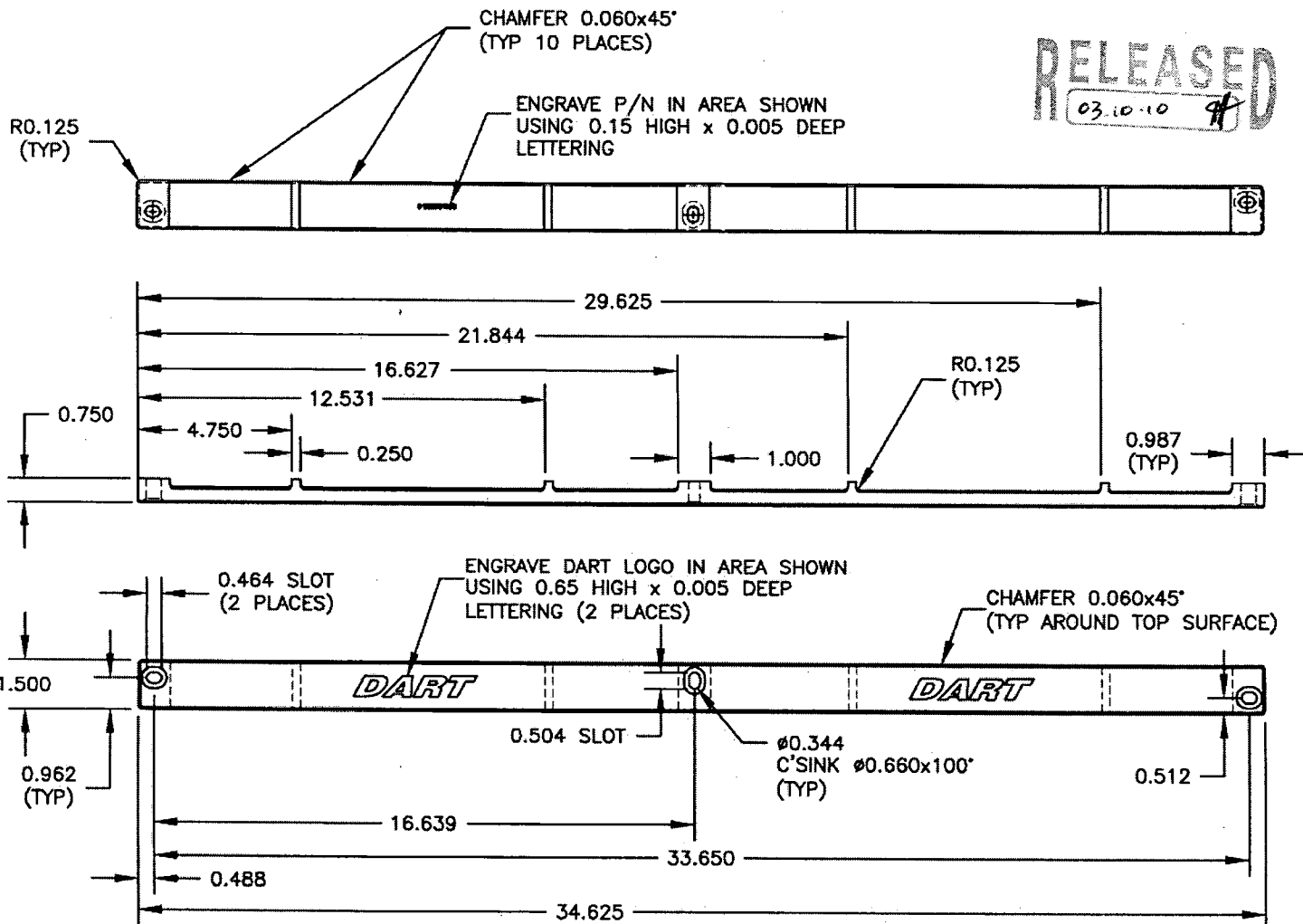
- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
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D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

NO. 25242

WORK OFF

SUBJECT TO

WITHOUT

ENGINEERING

REVISION

DATE

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
03.06.25	D3196	SHEET 3 OF 3
	TITLE	SCALE
	BAR	1:5